

Work Order ID 51428

August 24, 2009 10:44:25 AM



Page 1

Item ID: D2230-3

Accept



Setup Start



Revision ID: G

Stop



Item Name: Lug

Start Date: 24/08/2009 Start Qty: 200.00



Cust Item ID:

Required Date: 28/08/2009 Req'd Qty: 200.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 09-09-24 Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Band Saw ☐ Cut D2423 extrusion to 0.82" ☐ Batch: 45800

ML 09/08/26

200

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine per folio D2230-3 ☐ Check for crack while loading into the machine.

SL/Y.A
09/09/16

200

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL/Y.A
09/09/16

200

0

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Page 2

Item ID: D2230-3

Accept



Setup Start



Revision ID: G

Stop



Item Name: Lug

Start Date: 24/08/2009 Start Qty: 200.00



Cust Item ID:

Required Date: 28/08/2009 Req'd Qty: 200.00

Customer:

Reference: *24.08.24*

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

09/09/28
200

200 *0*

Quality Control

140

Small Fab

0.00



Small Fab

Memo

0.00

Tumble and deburr rough edges after tumbling

LD *09/09/29*

Small Fab

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

09/09/30

200 *0*

Hand Finishing

Work Order ID 51428

August 24, 2009 10:44:25 AM



Page 3

Item ID: D2230-3

Accept



Setup Start



Revision ID: G

Stop



Item Name: Lug

Start Date: 24/08/2009 Start Qty: 200.00



Cust Item ID:

Required Date: 28/08/2009 Req'd Qty: 200.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

27 80262130

200

6

170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:15pm								
	FINISH TIME: 1:45pm								
	OVEN TEMPERATURE: 326°F								

1112260

27 09109130

x 200

1

180	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

511 09-10-01

200

DART AEROSPACE LTD		Work Order:	
Description: Mounting Lug		Part Number:	D2230-3
Inspection Dwg: D2230 Rev: F		Page 1 of 1	

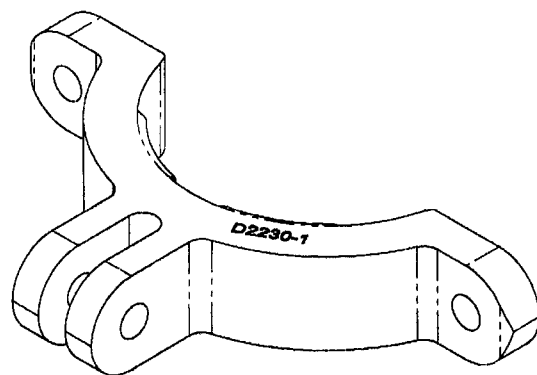
FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

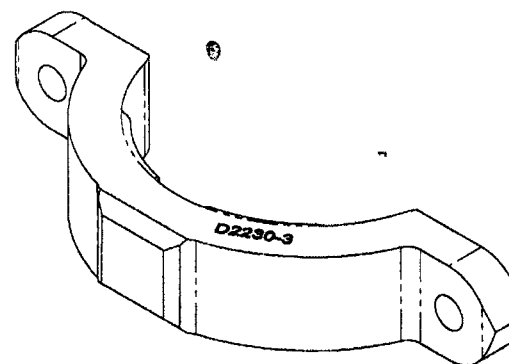
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010					
0.413	+/-0.010					
0.306	+/-0.010					
3.700	+/-0.010					
0.750	+/-0.010					
Ø0.257	+0.005/-0.000					
0.375	+/-0.010					
R1.200	+/-0.010					
0.100 x 45°	+/-0.010					
<div style="position: relative; height: 100px;"> <div style="position: absolute; top: 0; left: 0; right: 0; bottom: 0; border: 1px solid black; transform: rotate(-45deg); transform-origin: center;"> <div style="position: absolute; top: 10px; left: 10px; transform: rotate(-45deg);"> <p>Same as W/D</p> <p>51568</p> </div> </div> </div>						

Measured by: <i>SL</i> Date: <i>09/09/16</i>	Audited by: <i>ML</i> Date: <i>09/09/28</i>	Prototype Approval: <i>N/A</i> Date:
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Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

51428

RELEASED
01/26/2016

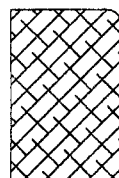


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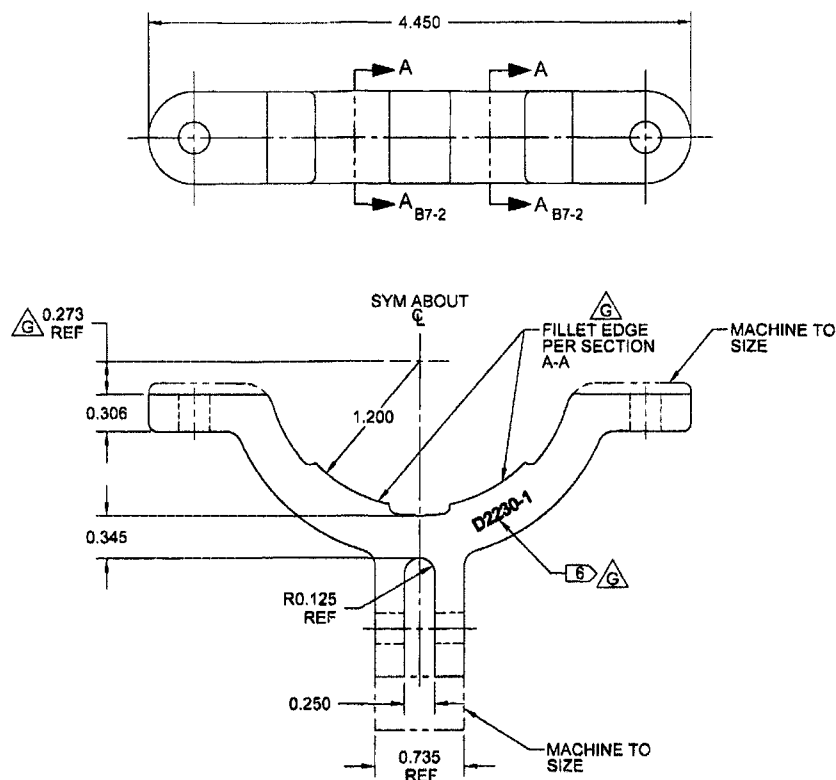
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015±0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	89.12.13
E	RE-DESIGN	BW	85.01.04
D	RE-DESIGN	BW	85.01.04
C	RE-DESIGN	BW	84.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

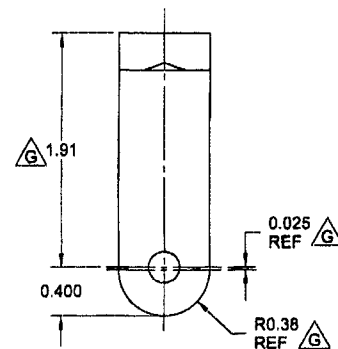
SECTION A-A D4-2
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-1 MOUNTING LUG



51428
RELEASED
07/06/75

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

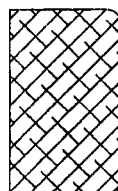
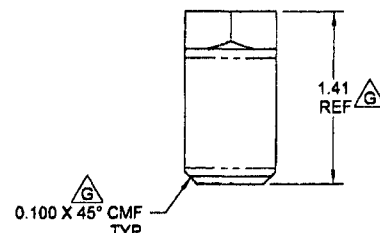
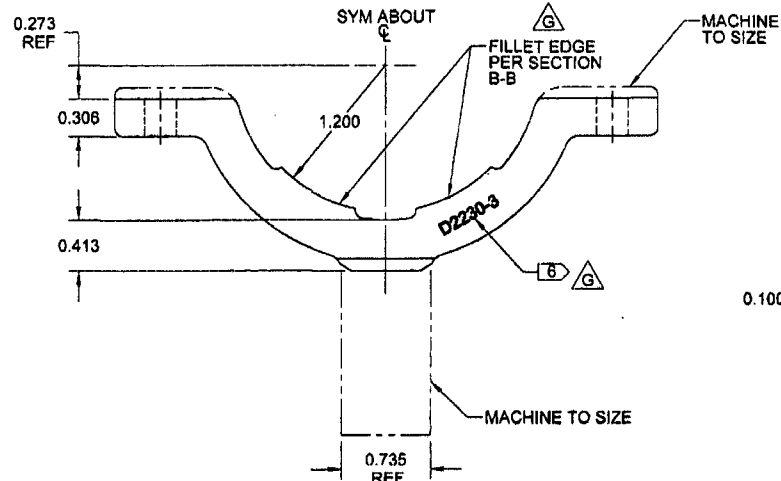
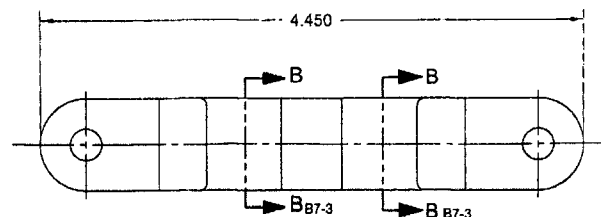
8 7 6 5 4 3 2 1

D

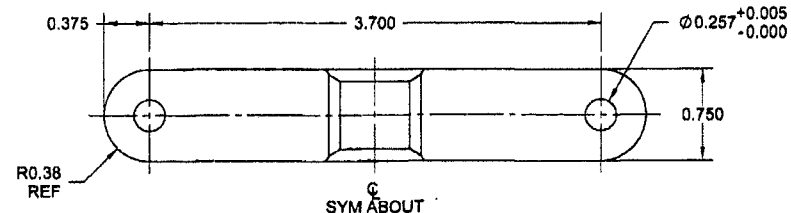
C

B

A



SECTION B-B D4-3
SCALE 2X
R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

51428

RELEASED
09/06/23 MP

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2230	REV. G
MFG. APPR.		TITLE MOUNTING LUG	SHEET 3 OF 3
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.01.16		

8 7 6 5 4 3 2 1